

Work Order ID 115342

March-26-14 10:19:36 AM

\*115342\*

Page 1

Item ID: D3536-13

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Gasket Fwd

Start Date: 3/26/14 Start Qty: 8.00

\*8\* 12  
\*8\*

Cust Item ID:

Required Date: 4/09/14 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-03-26 Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3536	Rev A
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100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: D3536 Prog Rev: A 2-  
Debur if necessary

12 mm / EL 14/04/01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

12 mm / EL 14/04/01

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
27  
9-8  
14/4/2

12

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\*115342\*

Page 2

Item ID: D3536-13

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Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 4/09/14

Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: FR001

0.00

\*130\*

Packaging

Memo

0.00

Packaging

12X

DAS  
28  
9-89

APR 03 2014

140

QC21 - Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

14-04-3

PLS 14-04-03

# Picklist Print

March-26-14 10:19:39 AM

Page 1

Work Order ID: 115342

**\*115342\***

Parent Item: D3536-13

**\*D3536-13\***

Parent Item Name: Gasket Fwd

Start Date: 3/26/14

Required Date: 4/09/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

1,120.100

0.8269

8

**\*MNEO60S 063\***

NEOPRENE SHEET 0.063

**\*\***

mm 14/04/01

Location

Loc Qty

Loc Code

MAT052

1120.1

M126546

27.1

M128266

293

M128339

800

93

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 115342
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-13
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	✓		T Jkm-07	
29.40	+/-0.030	29.40	✓		T	
27.40	+/-0.030	27.40	✓		T	
23.90	+/-0.030	23.90	✓		T	
18.98	+/-0.030	18.98	✓		T	
14.07	+/-0.030	14.07	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		✓ Jkm-05	
3.90	+/-0.030	3.90	✓		✓	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓	✓	T	
20.00	+/-0.030	20.00	✓		T	
1.89	+/-0.030	1.90	✓		✓	
0.30	+/-0.030	0.30	✓		✓	
0.30	+/-0.030	0.30	✓		✓	
Ø0.19	+0.005/-0.001	0.19	✓		✓	


<b>Measured by:</b> mm/EL	<b>Audited by:</b> DAS 27 9.80	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 14/04/06	<b>Date:</b> 14/4/06	<b>Date:</b>	N/A

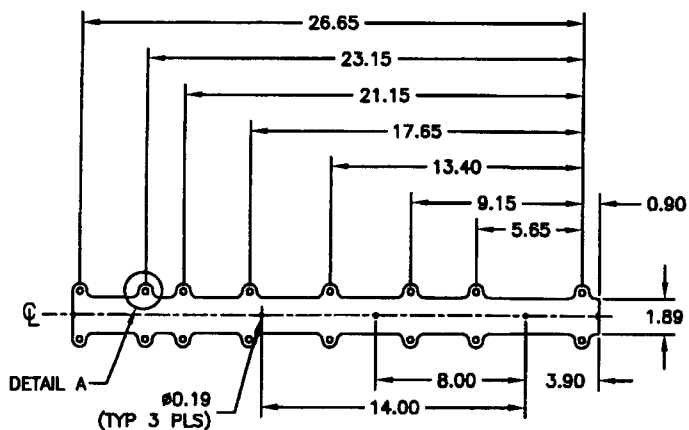
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

**DART**

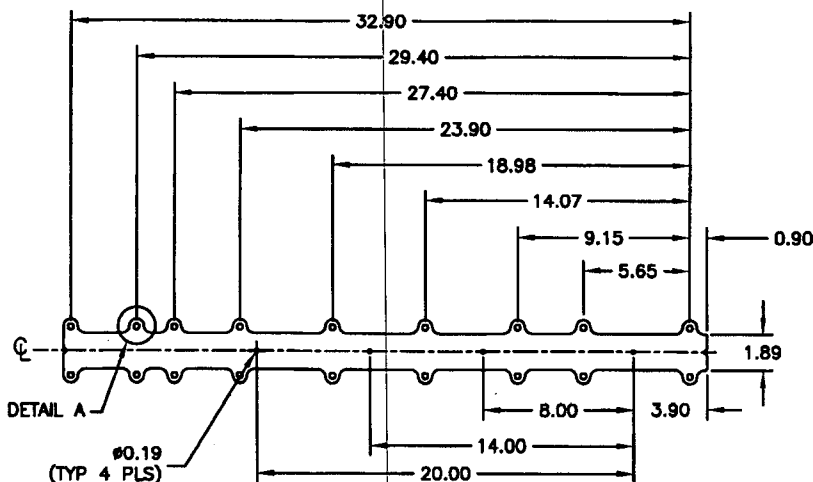
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09-02-12-11

115342 MJS  
14-03-26

DESIGN		DRAWN BY	DART AEROSPACE USA, INC.	
CB		CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.		REV. A
PH		D3536		SHEET 1 OF 8
DATE	TITLE		SCALE	
06.10.25	GASKET		1:10	
A	06.10.25	NEW ISSUE		



**D3536-11 GASKET**



**D3536-13 GASKET**

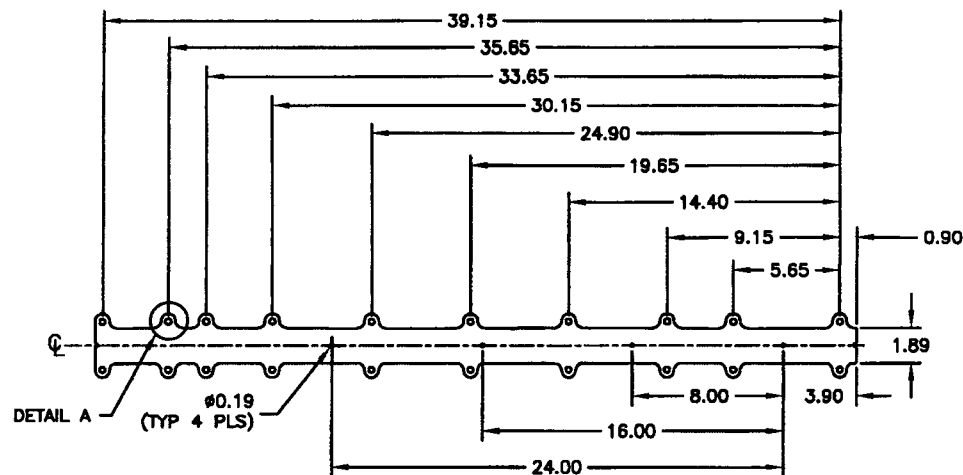
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

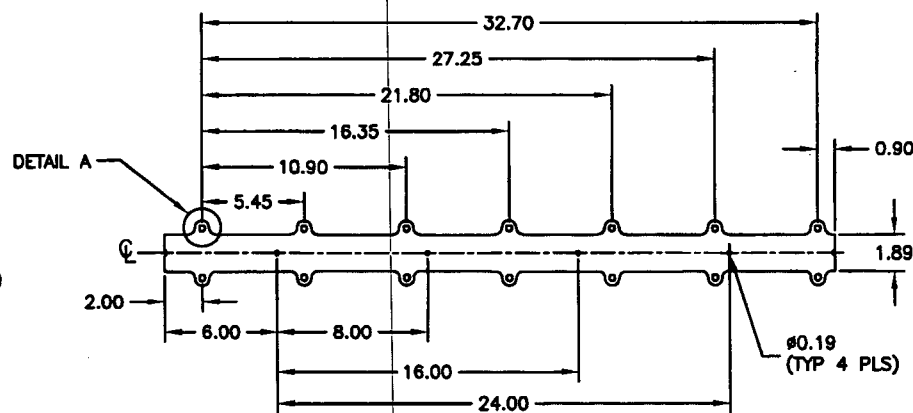
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070212

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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	SHEET 2 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SCALE <b>1:10</b>	



**D3536-15 GASKET**



**D3536-21 GASKET**

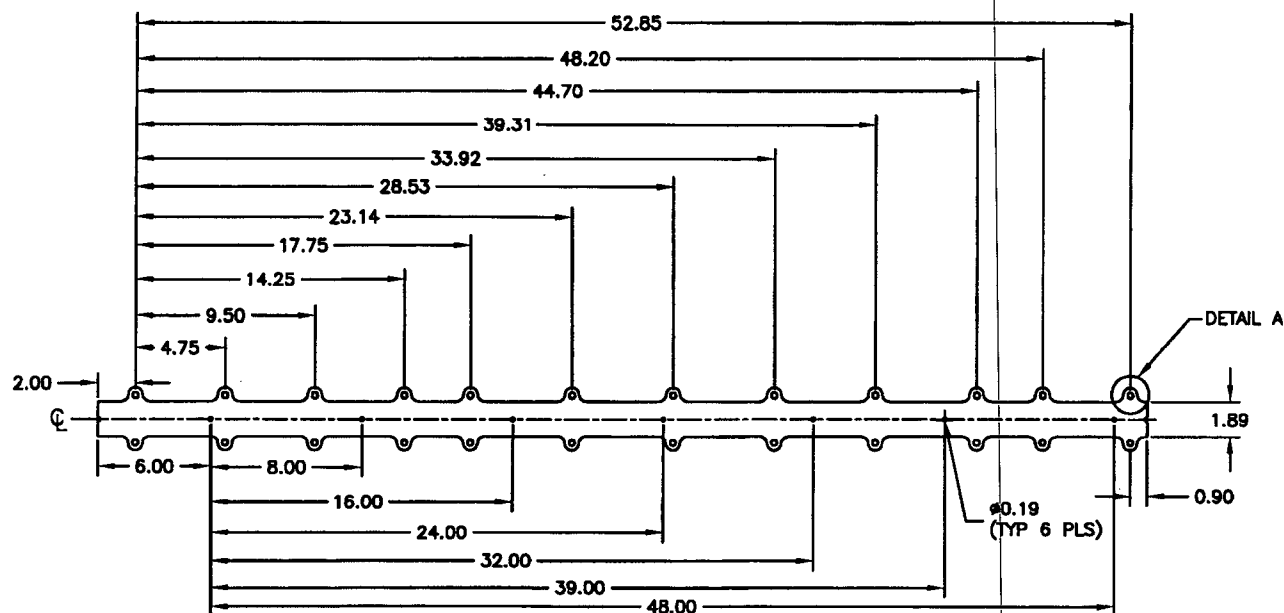
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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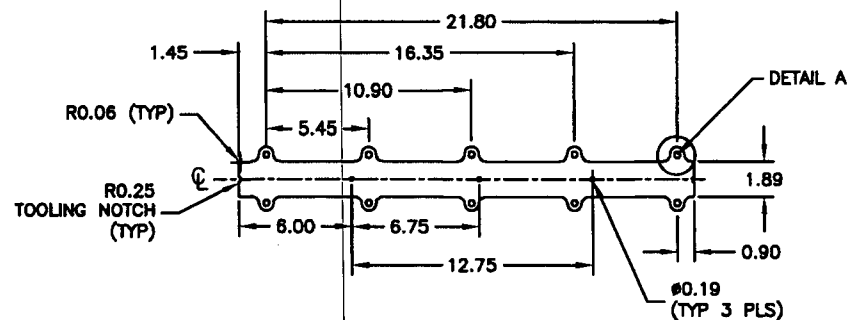


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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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07.02.12



**D3536-23 GASKET**



**D3536-25 GASKET**

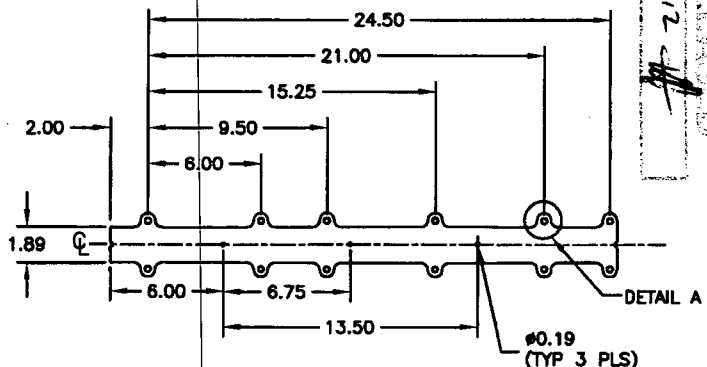
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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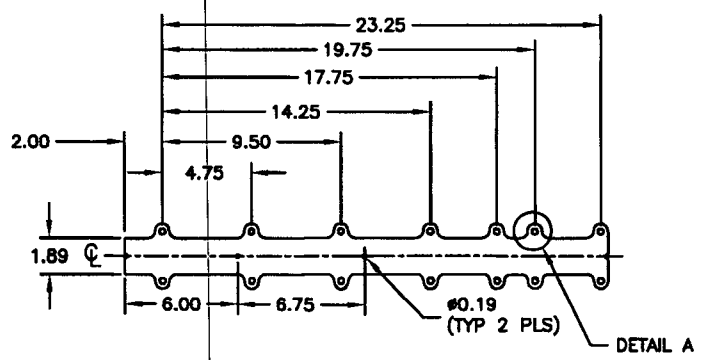
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 8
		SCALE	1:10	

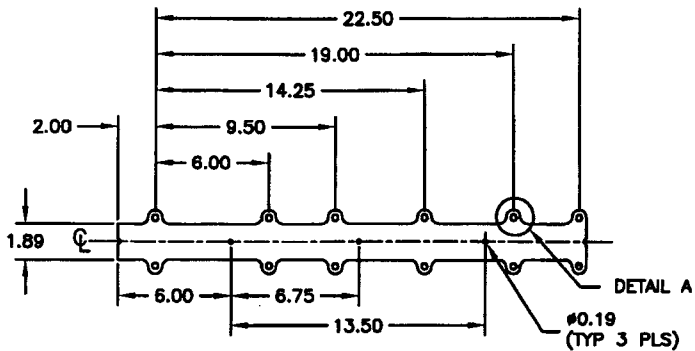
07.02.12



**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

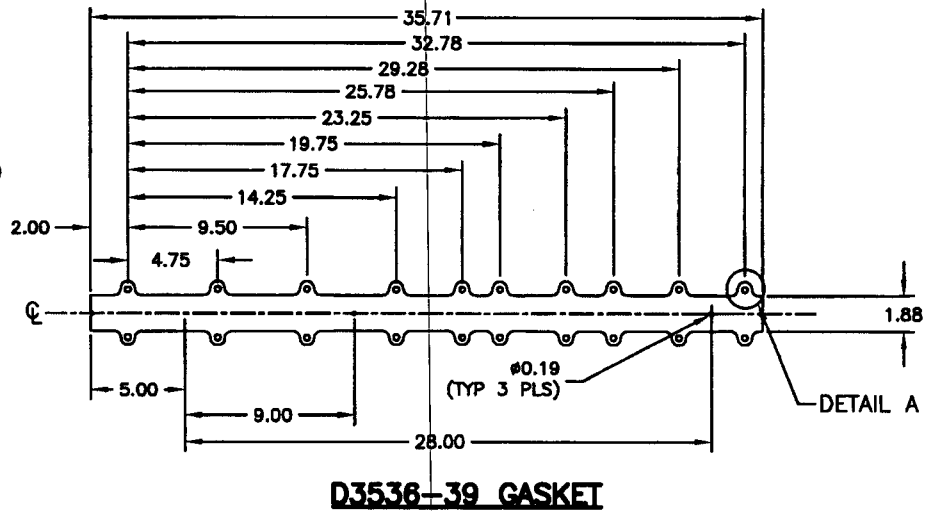
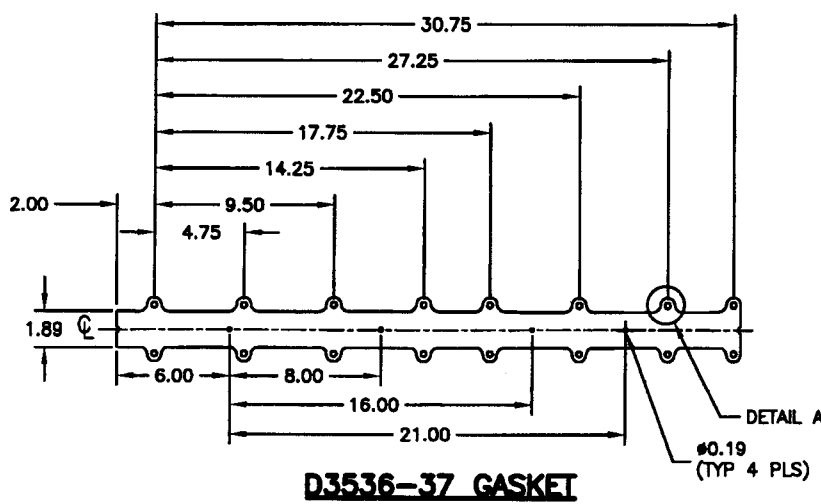
- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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07.02.02  
CH

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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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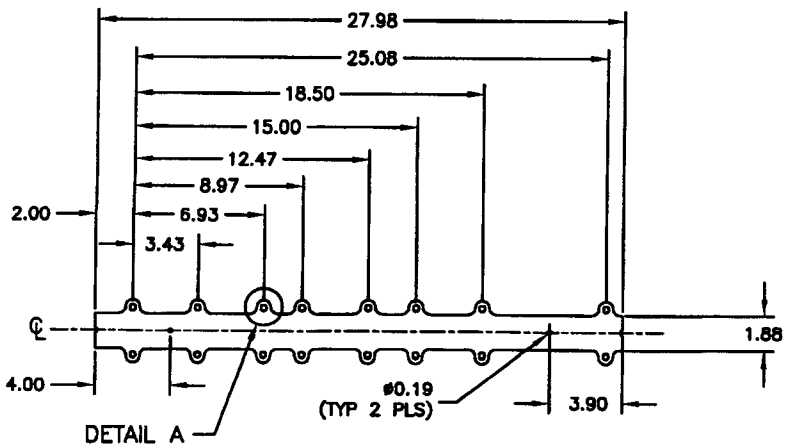
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DATE	06.10.25	TITLE	GASKET	REV. A	SHEET 6 OF 6
				SCALE	1:10

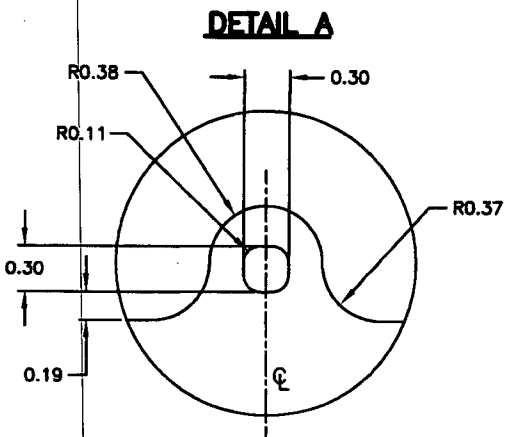
07.02.12 *AK*



**D3536-41 GASKET**

## NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE
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